

Work Order ID 111119

Thursday, January 09, 2014 11:30:19 AM

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Item ID: PB67-43001-29 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Blade Positioner Weldment
 Start Date: 1/8/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/24/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ME Date: 14-01-09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-29	C								

100 Weld per dwg A/R Aluminum rod Batch: 123128 0.00
 100 Large Fab

Memo 0.00
 ***FOR -337 LOCATE APPROX. AS SHOWN ASSURING 45 DEG.
 MOVEMENT OF -285 EACH SIDE OF VERTICAL, PRIOR TO
 WELDING***
 1- ASSEMBLE AND WELD AS PER DWG

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110 QC Memo 0.00
 Quality Control

2 6 GPC R
14-01-22 14-01-18

2 14-01-15 DAS
14-01-22 9
9-89

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Item ID: PB67-43001-29 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Blade Positioner Weldment
 Start Date: 1/8/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/24/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				①	14-01-15		DAS 9 9-89
Quality Control							14-01-22		
130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130	17111277.								
Powdercoat	Memo	0.00				2	14-1-29.		DAS 34 9-89
Powder Coating	START TIME: 8:40. OVEN TEMPERATURE: 320° FINISH TIME: 9:12								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							DAS 27 9-89 14/1/29
Quality Control						2			

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Item ID: PB67-43001-29

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade Positioner Weldment

Start Date: 1/8/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>Mezz2</u>	0.00							
150									
Packaging	Memo	0.00				2x	DAS 28 9-89	14-01-30	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 14-02-04

(H) 14-01-30

Picklist Print

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Work Order ID: 111119

Parent Item: PB67-43001-29

Parent Item Name: Blade Positioner Weldment

Start Date: 1/8/2014

Required Date: 1/24/2014

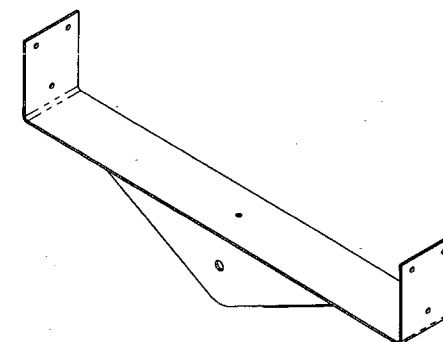
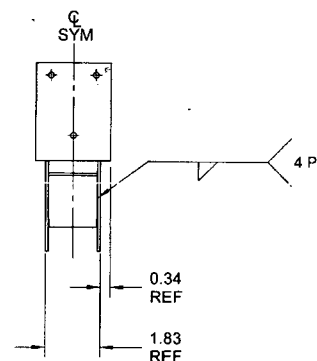
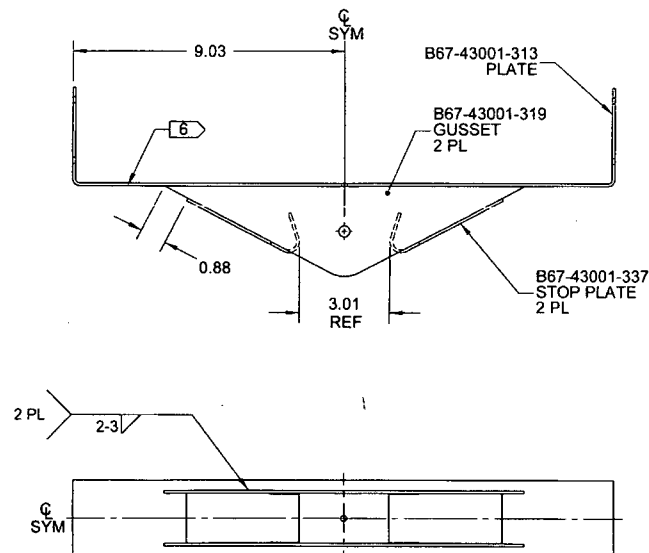
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-27 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-313 Plate		Manufactured	No			100	Each	10.0000	1	1		1/14-01-15	CPL 14-01-22
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		10							
				54672		10				2			CPL 14-01-22
PB67-43001-319 Gusset		Manufactured	No			100	Each	7.0000	2	2		1/14-01-15	CPL 14-01-22
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		7							
				99953		7				24			CPL 14-01-22
PB67-43001-337 Stop Plate		Manufactured	No			100	Each	5.0000	2	2		1/14-01-15	CPL 14-01-22
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		5							
				99952		5				24			

ITEM	QTY	P/N	DESCRIPTION
1	X	B67-43001-29	BLADE POSITIONER WELDMENT
3	1	B67-43001-313	PLATE
4	2	B67-43001-319	GUSSET
5	2	B67-43001-337	STOP PLATE



B67-43001-29 BLADE POSITIONER WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-29" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.01 lbs
- 8) WELDING: PER QSI 004

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 40 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.24
REV.	DESCRIPTION			BY	DATE
DESIGN	RW			DART AEROSPACE LTD	
DRAWN	J			HAWKESBURY, ONTARIO, CANADA	
CHECKED	JDS			DRAWING NO. B67-43001-29	
MFG. APPR.	J			REV. C	
APPROVED	J			SHEET 1 OF 1	
DE APPR.	N/A			TITLE	
DATE	09.06.24			BLADE POSITIONER WELDMENT	
				SCALE NTS	
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mf
111119
14-01-09

RELEASED
2009-09-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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